

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77072

77072

Page 2

November-25-11 10:25:50 AM

Item ID: K642-512 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: saddle kit 642-512
 Start Date: 25/11/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K642-512 Location: <u>PK</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/2/75

12/2/8

12-02-07

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

November-25-11 10:25:56 AM

Page 1

Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 05.06.07 new issue EC
IPP Rev.B 05.02.08, Per ECN1080P

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5C34A		Purchased	No			110	Each	73.0000	2	4			

Sr ***AN5C34A***

Location	Loc Qty	Loc Code
FG	2	
18918	2	
ST339	71	
117950	10	
118985	11	
119083	20	
119530	30	

D206-648-013

CHW

Manufactured No

110 Each 2.0000

1 2

Sr ***D206-648-013***
GHW Modification

**

Location	Loc Qty	Loc Code
FG125	2	
71578	2	

D2932-2

Manufactured No

110 Each 15.0000

1 2

Sr ***D2932-2***
Saddle RH Out, 206

**

Location	Loc Qty	Loc Code
ST428	15	
72515	1	
74602	8	
75100	6	

W/O:		WORK ORDER CHANGES					
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November-25-11 10:25:56 AM

Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C41A

Purchased

No

110

Each

208.0000

8

16

AN3C41A

BOLT

**

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

204

119035

44

119324

50

119530

60

119673

50

D2652

Manufactured

No

110

Each

799.0000

16

32

D2652

Bushing

**

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

755

73834

600

73835

119

73836

36

MS21043-3

Purchased

No

110

Each

717.0000

20

40

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

645

118077

1

118614

477

118686

167

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

November-25-11 10:25:57 AM

Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

D3672-7 Manufactured No

110 Each 1,188.000 24 48

**

D3672-7

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1188

73488

188

76279

1000

AN5C11A Purchased No

110 Each 170.0000 8 16

**

AN5C11A

Bolt

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

166

118706

16

118983

50

119127

50

119328

50

AN5C12A Purchased No

110 Each 86.0000 4 8

**

AN5C12A

BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

84

118983

40

119328

44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-25-11 10:25:57 AM

Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

AN5C13A

Purchased

No

110

Each

187.0000

4

8

**

AN5C13A

BOLT

Location

Loc Qty

Loc Code

ST338

187

117872

12

118983

75

119537

100

AN960C516L

NAS1149C0532
R

Purchased

No

110

Each

0.0000

8

16

**

***AN960C516I ***

WASHER

AN4C6A

Purchased

No

110

Each

528.0000

12

24

**

AN4C6A

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

524

116704

15

118451

9

118983

100

119328

200

119749

200

D3672-3

Manufactured

No

110

Each

1,180.000

24

48

**

D3672-3

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1180

64176

180

73487

500

76278

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

AN960C416L

Purchased

No

110

Each

0.0000

24

48

***AN960C416I ***

WASHER

MS21043-4

Purchased

No

110

Each

1,457.000

13

26

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1417

117793

5

118686

470

119309

442

119546

500

D3407-043

Manufactured

No

110

Each

33.0000

1

D3407-043

Low Ring

Location

Loc Qty

Loc Code

ST463

31

68339

2

73341

7

74519

22

ST464

2

68339

0

71040

1

72513

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

D3456-1

Manufactured No

110 Each

65.0000

1

**

D3456-1

Washer

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

58

66848

3

71165

2

73493

53

D3457-1

Manufactured No

110 Each

24.0000

2

**

D3457-1

Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

14

67779

1

70774

4

71849

9

D2712

Manufactured No

110 Each

2,211.000

10

**

D2712

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

2161

71160

1

73837

160

76065

2000

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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November-25-11 10:25:57 AM

Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

D2934

Manufactured No

110

Each

70.0000

2

D2934

Saddle Spacer

**

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

29

74501

29

ST028

35

74883

35

D2935

Manufactured No

110

Each

60.0000

2

D2935

Saddle Spacer

**

Location

Loc Qty

Loc Code

ST027

30

74503

30

ST028

30

74882

30

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

AN3C36A

Purchased

No

110

Each

197.0000

9

18

**

AN3C36A

BOLT

Location

Loc Qty

Loc Code

FG

14

101261

4

116590

10

ST303

20

118757

20

ST353

163

116590

0

119083

2

119125

1

119324

100

119530

60

AN3C35A

Purchased

No

110

Each

111.0000

3

**

AN3C35A

BOLT

Location

Loc Qty

Loc Code

FG

4

18914

4

ST353

107

118628

7

119125

50

119449

50

AN960C10L

NAS1149C0332

Purchased

No

110

Each

0.0000

24

48

**

*AN960C10L *

washer

November-25-11 10:25:57 AM

Shop Packet Print

Page 9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

November-25-11 10:25:57 AM

Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

D3672-1

Manufactured No

110

Each

1,188.000

24

48

D3672-1

Phenolic Washer

**

Location

Loc Qty

Loc Code

FP

424

66821

424

ST074

764

72229

264

76277

500

48

D3396-3

Manufactured No

110

Each

73.0000

2

D3396-3

Spacer

**

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

63

73349

63

Y

AN5C35A

Purchased

No

110

Each

68.0000

1

AN5C35A

**

Location

Loc Qty

Loc Code

ST340

68

108407

18

118451

25

119749

25

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-25-11 10:25:58 AM

Work Order ID: 77072

77072

Parent Item: K642-512

K642-512

Parent Item Name: saddle kit 642-512

Start Date: 25/11/2011

Required Date: 09/12/2011

Start Qty: 2.00

Required Qty: 2.00

AN5C15A

Purchased

No

110

Each

82.0000

**

AN5C15A

Bolt

Location

Loc Qty

Loc Code

ST338

82

118191

7

118267

50

119749

25

AN5C32A

Purchased

No

110

Each

103.0000

**

AN5C32A

Location

Loc Qty

Loc Code

FG

4

18918

4

ST339

99

117407

25

117969

24

119035

50

MS21043-5

Purchased

No

110

Each

627.0000

**

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

ST301

507

112314

182

116548

100

119307

25

119537

200

ST314

100

118159

100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
1	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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